

Work Order ID 83946

83946

Page 1

April-27-12 2:54:29 PM

Item ID: D2803-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket Assembly

Start Date: 27/04/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MJS

Date: 12/04/27 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2803

Rev B

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

Press D2805-1 and D2809 into arm as per Dwg D2803

6x

12/06/05

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

(6)

12/06/05

120

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

120

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

32005

200

6x

12/06/05

m121134

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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April-27-12 2:54:29 PM

Item ID: D2803-041
Revision ID:
Item Name: Bracket Assembly

Accept

N9000040100

Setup Start ***NS1***
Stop ***NS2***

Start Date: 27/04/2012 Start Qty: 4.00 ***4***
Required Date: 11/05/2012 Req'd Qty: 4.00 ***4***

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 QC3- Inspect Part Finish

0.00

130

QC Memo

0.00

Quality Control

6 0 1265

150 Small Fab

0.00

150

Small Fab Memo

0.00

Small Fab Assemble as per Dwg D2803.

6x

12/06/06

160 QC5- Inspect part completeness to step on W/O

0.00

160

QC Memo

0.00

Quality Control

8/16/06

6x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D2803-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket Assembly
 Start Date: 27/04/2012 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 11/05/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>ST 145</u>	0.00							
170									
Packaging	Memo	0.00				6		546	12/06/06
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							12/6/8 20
Quality Control									

12-06-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 83946

83946

Parent Item: D2803-041

D2803-041

Parent Item Name: Bracket Assembly

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2803-1 *D2803-1* Bracket		Manufactured	No			100	Each	3.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>					
				ST148				3					
					75079			1					
					79081			2					
D2805-1 *D2805-1* Stop		Manufactured	No			100	Each	6.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>					
				GA				6					
					79525			6					
NAS1515H3 *NAS1515H3* Washer		Purchased	No			100	Each	190.0000	4	16			
				<u>Location</u>				<u>Loc Qty</u>					
				ST277				190					
					118078			6					
					119438			4					
					120142			11					
					120518			26					
					120770			43					
					121415			100					

12/06/05
B82583
(4x)

12/06/05
B83942
2x

12/06/05
M121649
(24x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

Work Order ID: 83946

83946

Parent Item: D2803-041

D2803-041

Parent Item Name: Bracket Assembly

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 4.00

Required Qty: 4.00

AN3C16A

Purchased

No

150

Each

68.0000

2

8

AN3C16A

Bolt

**

EP 12/06/05

Location

Loc Qty

Loc Code

ST352

68

115835

1

118422

4

120498

38

121349

25

812

D2809

Manufactured

No

150

Each

40.0000

1

4

D2809

Bushing

**

EP 12/06/05

Location

Loc Qty

Loc Code

GA

24

72735

7

80557

17

ST018

16

34035

12

77292

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 3

Work Order ID: 83946

Parent Item: D2803-041

Parent Item Name: Bracket Assembly

83946

D2803-041

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 4.00

Required Qty: 4.00

MS21043-3

Purchased

No

150

Each

1,097.000

2

8

MS21043-3

Nut

**

JS 12/06/05

Location

Loc Qty

Loc Code

FG

72

103691

72

GA

124

120693 -

124

ST301

901

118077

2

118614

83

118686

30

119758

20

121255

766

12

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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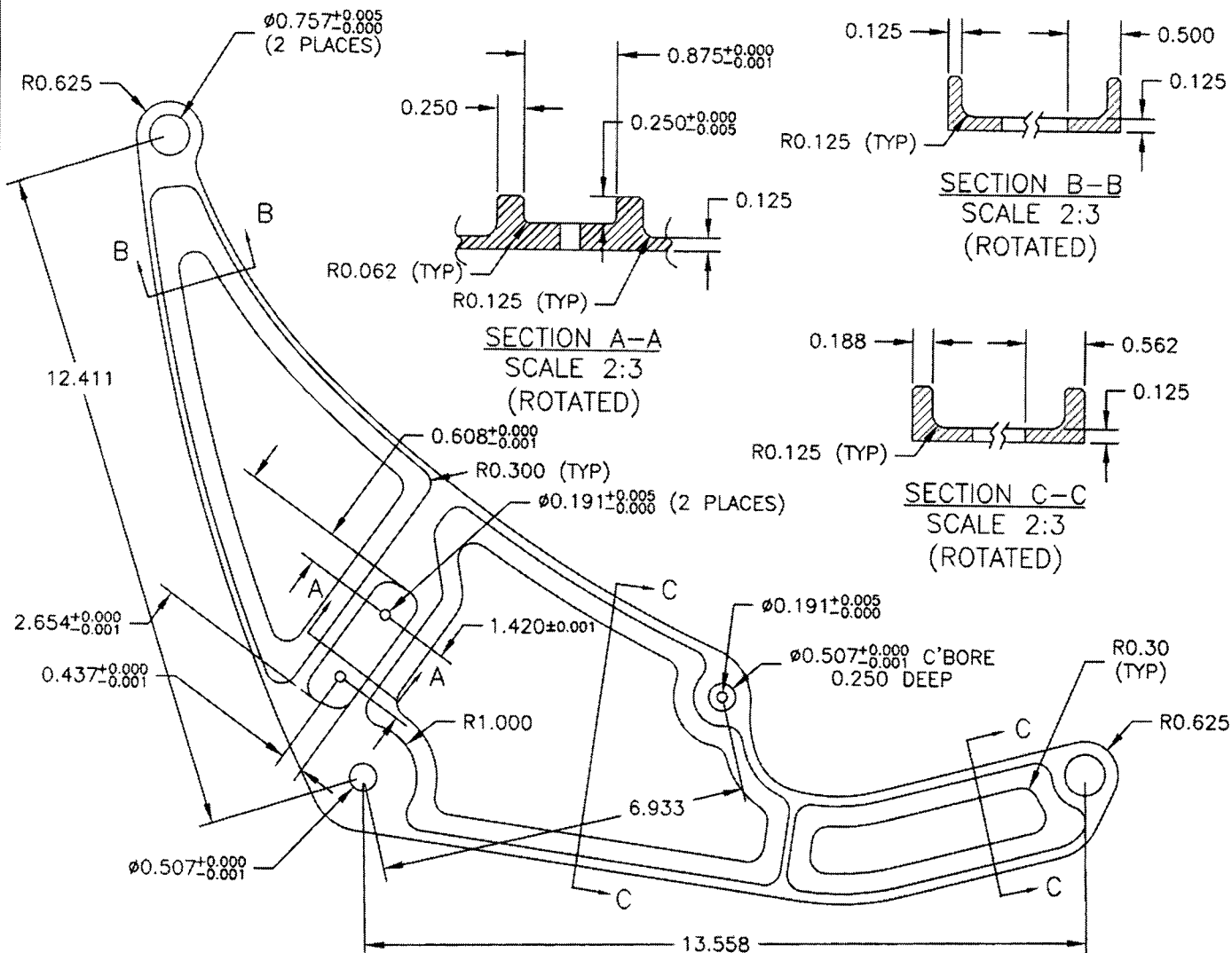
NOTE: Date & initial all entries

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO. D2803
				REV. B
DATE	04.11.22	TITLE	STA 84 BRACKET	SHEET 1 OF 2
				SCALE 1:3
A	00.11.07	NEW ISSUE		
B	04.11.22	ADD CUTOUTS & -043/-044		

RELEASED

05-03 11

**D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83946
12/01/24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

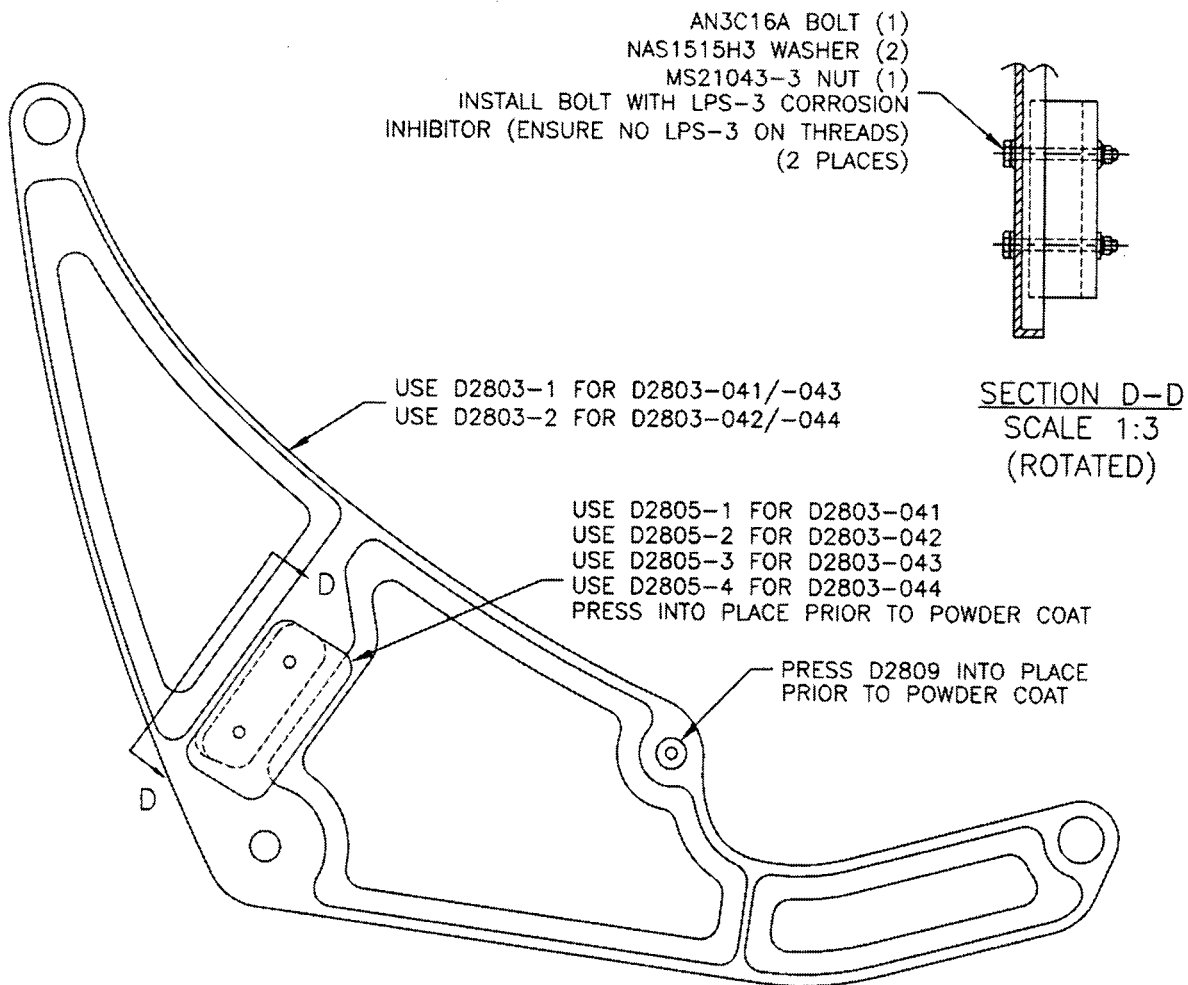
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



RELEASED

05-03.11

D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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